

Date: Monday, 1/14/2008 2:37:45 PM
User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---|------------------|-----------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : DOUBLER |
| Job Number | : 36757 | | |
| Estimate Number | : 12109 | | |
| P.O. Number | : | Part Number | : D32014 |
| This Issue | : 1/14/2008 S.O. No. : | Drawing Number | : D3201 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : SMALL /MED FAB | Drawing Revision | : B |
| Previous Run | : 32475 | Material | : |
| Written By | : | Due Date | : 2/5/2008 Qty: 40 Um: Each |
| Checked & Approved By | : <u>08 01 15</u> | | |
| Comment | : Est Rev: A Removed from 9 Digit 06-01-25 JLM | | |
| | : Est Rev: B Now on Waterjet 06-08-14 JLM | | |
| | : Est Rev: C Added scribing, NCR262 07.11.29 EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S050 | 2024-T3 .050 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.0473 sf(s)/Unit Total : 1.8900 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.050" thick
(M2024T3S.050)
Batch: 105646 IB 8-1-16

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
1-Cut as per Dwg D3201
Dwg Rev: B IB 8-1-16
Prog Rev: B

2-Deburr if necessary

08/01/17 (46)

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

08/01/17 (46) counts

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

08/01/17 (46)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/29
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:45 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36757

Part Number: D32014

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Bend as per Dwg D3201

2-Scribe part# and Batch# per dwg D3201

SRB 08/01/18

(46)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/22 (46)

coaster

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-01-24 (46)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-01-24

(46)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5776

08/04/25

(46)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/29

(46)

Job Completion



08/01/28

W

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

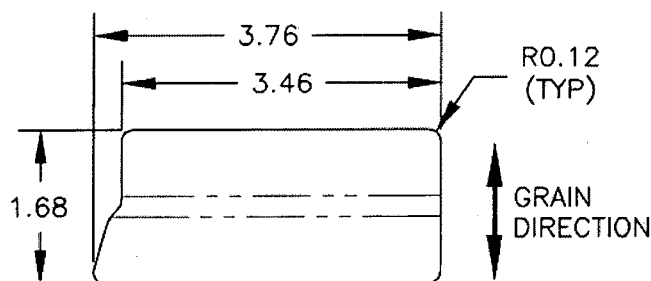
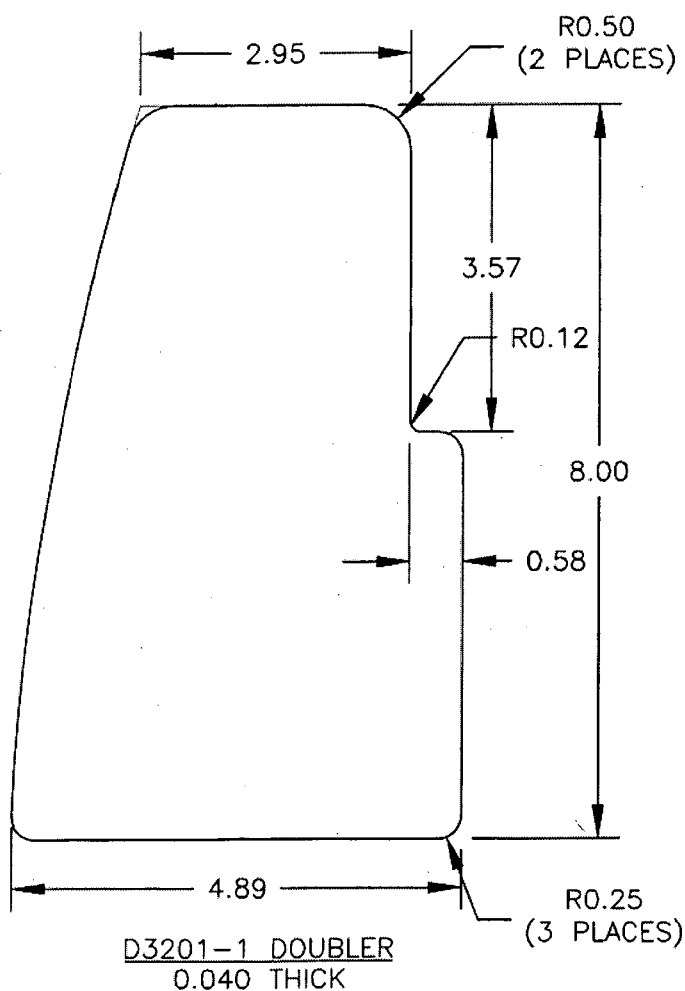
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

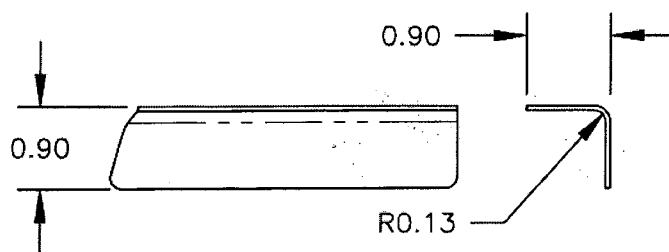


| | | | |
|----------|----------|--------------------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| | CP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. B |
| | | D3201 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |
| 03.11.03 | | DOUBLER | 1:2 |
| A | 03.08.07 | NEW ISSUE | |
| B | 03.11.03 | MODIFY D3201-1, ADD D3201-3/-4 | |

RELEASED
03.11.14



D3201-3 ANGLE (SHOWN)
D3201-4 ANGLE (BEND OPPOSITE)
0.050 THICK



D3201-1/-3/-4 DOUBLER

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36757

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.